

18

Date: Wednesday, 13/05/2009 11:28:36 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 407 STEP ASSEMBLY
Job Number	: 47933		
Estimate Number	: 11798		
P.O. Number	:	Part Number	: D206628034
This Issue	: 13/05/2009 S.O. No. :	Drawing Number	: N/A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: N/A
Previous Run	: 46698	Material	:
Written By	:	Due Date	: 29/05/2009 Qty: 8 Um: Each
Checked & Approved By	: <u>JLD 09.05.13</u>		
Comment	: Est Rev:D As Per Ecn 766 06-01-06 JLM Est Rev:E as per ecn 1118 08-02-05 DD verified by:EC est rev F ncr 09-004 09.01.09 EC verified by:DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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for JLD 09/06/02
Rev. B
Monteallos



Comment: DOCUMENT CONTROL Ecn 1118 DSI 9332 Rev. B
 Photocopy blue file and type labels as per PPP D206-628-034 CHG 0023

5 09/06/10

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

3.0	47933A	FLOAT STEP ASSEMBLY RH (206/407)
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5 (x8) 4



Comment: Sub-Component 206B STEP ASSY, LH
 1 x D2842-042 Batch 47933A 50

4.0	D2732	Rubber Extrusion
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Comment: Qty.: 2.0000 f(s)/Unit Total : 16.0000 f(s)

Qty	Part #	Description	Batch
8	D2732	RUBBER CUSHION	<u>38509</u>

CUT EIGHT PIECES 3.00" LONG

measured 5/15/02

18 09/06/02 (x8)

5.0	D27313	Mounting Lug
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	D2731-3	Mounting Lug	<u>343313</u> <u>+24</u>

347967 01 9/6/09

18 09/06/02 (x8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 13/05/2009 11:28:37 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 STEP ASSEMBLY

Job Number: 47933

Part Number: D206628034

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D28441

Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2844-1

Arm

46844

SS 09/06/02

x8

7.0

D28443

Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2844-3

Arm

B46845

SS 09/06/02

x8

8.0

D3394041

Lug Assembly



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 D3394-041

LUG ASS,Y

B46861

x21

SS 09/06/02

x8

9.0

AN4C14A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN4C14A

Bolt

M110105

SS 09/06/02

x8

10.0

AN3C4A

BOLT



Comment: Qty.: 3.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 AN3C4A

Bolt

M111668

SS 09/06/02

x8

11.0

AN4C15A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4C15A

Bolt

M111279

x15

SS 09/06/02

x8

Date: Wednesday, 13/05/2009 11:28:37 AM
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Process Sheet

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Drawing Name: 407 STEP ASSEMBLY

Job Number: 47933

Part Number: D206628034

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN960C10

WASHER



Comment: Qty.: 3.0000 EACH(s)/Unit Total : 24.0000 EACH(s)

Pick:

Qty Part Number Description Batch
3 AN960C10 WASHER

M109165

SS 09/06/02 (x8)

13.0

AN960C416L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total : 192.0000 Each(s)

batch:

M111650 x88 M111916 x104

SS 09/06/02 (x8)

14.0

NAS1515H4L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total : 192.0000 Each(s)

Pick:

Qty Part Number Description Batch
24 NAS1515H4L Washer

M111359

SS 09/06/02 (x8)

15.0

MS210434

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 96.0000 Each(s)

Pick:

Qty Part Number Description Batch
12 MS21043-4 Nut (or MS21042-4)

M111819

SS 09/06/02 (x8)

16.0

NAS1515H3

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number Description Batch
3 NAS1515H3 Washer

M110397

SS 09/06/02 (x8)

17.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

SS 09/06/10 (x6 RH)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-628-024

Location:

D 09/06/10

Date: Wednesday, 13/05/2009 11:28:37 AM
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Job Number: 47933

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Job Number:



Seq. #:

Machine Or Operation:

Description :

PPP Rev: _____

19.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/10 *MF*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-06-10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries